

5/30

SPLIT

DART AEROSPACE LTD	Work Order:	23772A
Description: Jack	Part Number:	D3336-1
Dwg: D3336 Rev. A	Qty:	104
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	05.07.6	10
2	PG	Issue P/O: <u>2008334</u> For D3336-1 Jack P/N: 76508 Possible Supplier: Auto Parts Product Specification sheet is required	HA	05/07/06	10
3	RG	Receive and Inspect for transit damage Ensure Product Specification sheet is attached	DL	05/07/09	4
4	MFA	Drill and Tap base of jack using DT8761 as per Dwg D3336	CPL	06.02.10	4
5	MFA	Check ram length, then tack weld as per Dwg D3336	CPL	06.02.10	4
6	MFA	Drill and Tap ram as per Dwg D3336			
7	QC5	Inspect work to Step 6		06.02.13	4
8	ST	Identify and Stock	CPL	06.02.13	4
9	AC	Cost / part: _____	U	06.02.27	4
10	DC	Close W/O Inspect Level 21	Q	06.02.27	4





Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	

Remove from stock 4 x 51618015C
see back of drawing

RELEASED
05.01.13

M19705

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-02-13	6	Hole size for trap too big, not enough thread on inside of hole.		use 5/16 bolt in hole, and remove head. ensure bolt is 90° to head of Dack. See Attached sketch on back of Descy.	CPL 06-02-13			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/02/13

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

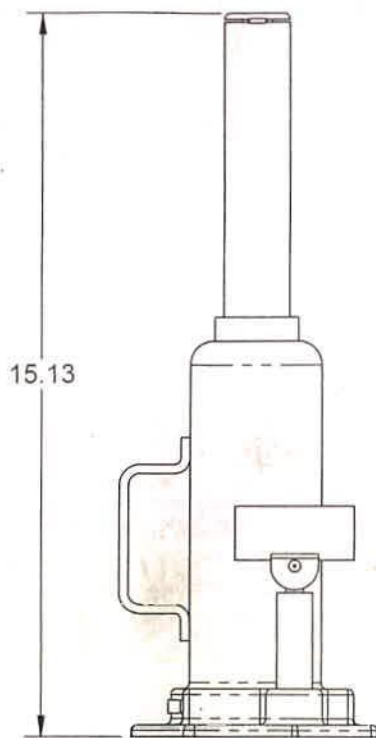
DART AEROSPACE LTD	Work Order:	23772A
Description: Custom W/O to repair weld cap hole	Part Number:	D3336-1
Dwg: D3336 Rev. A (Repair)		
Ref: N/A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>[Signature]</i>	05.09.06	4
2	WFA	Fabricate (4) stud as per D3336 dwg. Material: 1045 HSDP Ø0.875 round bar. <i>111018</i>	<i>[Signature]</i>		
3	QC5	Inspect stud as per D3336 dwg.			
4	MM	Repair cap. Open hole to Ø0.625 to 0.75 depth. <i>06-02-10</i> <i>SEE HAND DRAWING</i>			
		<u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u> 4 D3336-1 Jack B23772A	<i>CPL</i>	<i>06-02-10</i>	<i>4</i>
5	QC5	Inspect jack as per D3336-1 dwg.			
6	WFA	Weld Stud in the jack cap as per D3336 dwg. <i>WELD. BOLT W JACK CAP</i>	<i>[Signature]</i>	<i>06-02-10</i>	<i>4</i>
7	QC9	Inspect work to Step 6			
8	WFA	Return to original w/o B23772A.			
9	AC	Cost / part: <i>N/A</i>			
10	DC	Close W/O Inspect Level 21 <i>05.09.06</i>			

Rev	Date	Change	Revised By	Approved
A	05.09.06	New Issue	RF	<i>[Signature]</i>

DART

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED [Signature]	DRAWING NO. D3336 (REPAIR)	REV. A SHEET 1 OF 1
DATE 04.12.16	TITLE JACK	SCALE 1:2	
A	04.12.16	NEW ISSUE	



DETAIL A: SIDE VIEW
SCALE 1:4

WELD STUD
FLAT AT THIS
SURFACE

0.063-0.125 x
45° CHAMFER

OPEN HOLE TO $\phi 0.625$ "
0.75" DEEP

DRILL 0.201 x 1.00 DEEP
AND TAP 1/4-20 x 0.75 DEEP
AT CENTER OF CAP.

WELD CAP WITH SHAFT
WITH 0.375 LONG
TACKS (2 PLACES)
AROUND PERIMETER

RELEASED
05/02/09

DRILL 0.312 PER
TEMPLATE DT8761
(2 PLACES)

0.75 $+0.000$
 -0.030

$\phi 0.620$ $+0.004$
 -0.000

COUNTER BORE $\phi 0.38$
IF NECESSARY FOR
CLEARANCE OF BOLT
HEAD (2 PLACES)

TRIM EDGES AS PER
TEMPLATE DT8761
AND PAINT CUTS TO
MATCH COLOR.

DRILL $\phi 0.201$ THRU
TAP 1/4-20
THREADS

0.12 x 45°
CHAMFER

D3336-1

NOTES:

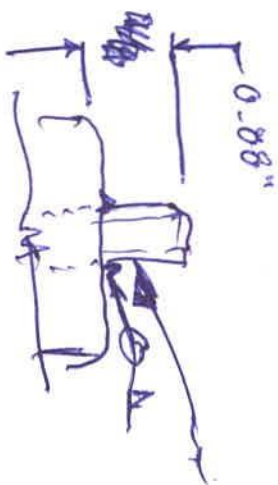
- 1) MATERIAL: 8 TONS JACK. POSSIBLE SUPPLIER: AUTOPARTS
MODEL NUMBER 76508
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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FILL HOLE WITH
WELD AND GRIND
FLUSH TO SURFACE.

CAD OR D3336-1



CUT OR
HEAD OF
WELD IN D3336-1 HOLE AND
WELD.

06-02.10

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 06, 2005
11:42 am

Work Order No : 0023772
Project Name : D3336-1
Project For : WK530
Work Order Type : Main
Main WO Number :
House Part Number : D3336-1
Description : Jack
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 07-06-05
Est Finish Date : 07-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

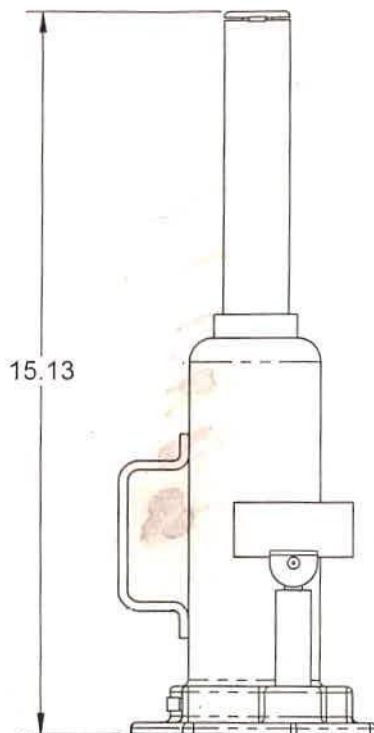
Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED [Signature]	DRAWING NO. D3336	REV. A SHEET 1 OF 1
DATE 04.12.16	TITLE JACK	SCALE 1:2	
A	04.12.16	NEW ISSUE	



DETAIL A: SIDE VIEW
SCALE 1:4

DRILL 0.312 PER
TEMPLATE DT8761
(2 PLACES)

COUNTER BORE $\varnothing 0.38$
IF NECESSARY FOR
CLEARANCE OF BOLT
HEAD (2 PLACES)

DRILL 0.201 x 1.00 DEEP
AND TAP 1/4-20 x 0.75 DEEP
AT CENTER OF CAP.

WELD CAP WITH SHAFT
WITH 0.375 LONG
TACKS (2 PLACES)
AROUND PERIMETER

RELEASED
05/02/09

TRIM EDGES AS PER
TEMPLATE DT8761
AND PAINT CUTS TO
MATCH COLOR.

D3336-1

NOTES:

- 1) MATERIAL: 8 TONS JACK. POSSIBLE SUPPLIER: AUTOPARTS
MODEL NUMBER 76508
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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UNCONTROLLED COPY
REQUEST TO
WITHDRAW NOTICE

WORK ORDER
NO. 23772



**AUTO PARTS EXTRA PIÈCES D'AUTO
TRUCK PARTS EXTRA PIÈCES DE CAMION
AGRI-FARM EXTRA FERME-AGRI
ENGINES EXTRA MOTEURS
TIRES EXTRA PNEUS**



C-04605

Past due accounts bear 2% interest per month (24% per annum). If this account is placed with a 3rd party collection, an administrative cost of 25% will be added. All exchanges and refund claims must be accompanied by this invoice. Electrical parts not returnable. All parts returned are subject to 20% handling charge. All merchandise sold on this invoice remains the vendor's property until this invoice is paid in full.
TERMS: Payment due on 10th day of the following month.

Aucun remboursement sans cette facture. Net 30 jours, 2% de frais d'intérêt par mois (24% par année) sur compte en souffrance. 20% de frais de manutention sur toute marchandise retournée. Clause pénale une indemnité de 25% sera chargée sur compte sujet à des procédures légales. Les marchandises mentionnées sur cette facture demeurent la propriété du vendeur tant qu'elles ne seront pas entièrement payées. Pièces électriques non-retournable.
TERMES: Compte payable le 10 du mois suivant.

SIGNATURE _____

GST / TPS
10035 3366 RT0001

1000 RUE LANDSDOWNE
TEL: (613)632-1191

HAWKESBURY, ON K6A 1H7
FAX: (613)632-2350

TVQ
1016330716 TQ0001

GST/TPS 10035 3366 RT0001

PST/TVQ 1016330716 TQ0001

113336 (613)632-3336
DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

EXP
SHIP
PI
D
I
E
R
TO
À

113336

SAME

DATE: 7/18/05
13:14
111 ZZZ

PO:
2008334

ORD / COM	SHIP / EXP	CODE	PART No / PIÈCES	DESCRIPTION	LIST EACH / CHACUN	COST / COÛTANT	EXTENSION
4	4	G2S>	NOR76508	8 ton axle jack		120.00	480.00
			g2s 532948				0.00
	4	***	6 autre a suivre				
			SHIP VIA	PIECES/CORE TOT REGULAR	0.00		
Dand Galiberto							
INVOICE No / FACTURE	TYPE / SORTE	TOTAL	DISC / ESC	FRT / TRANS	GST / TPS	PST / TVQ	AMT to PAY / À PAYER
11672249	INVOICE	480.00	0.00	0.00	33.60	0.00	513.60

VERSUS BUSINESS FORMS (CORNWALL) (613) 936-1852

474-44

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:36 am

Work Order No : 0023772
Project Name : D3336-1
Project For : WK530
Work Order Type : Main
Main WO Number :
House Part Number : D3336-1
Description : Jack
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 07-06-05
Est Finish Date : 07-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	1200.00	100.00	0.00	1200.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	15.67	100.00		
Production Cost :	0.00	255.86	100.00	0.00	255.86
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	1455.86	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	1455.86			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-1455.86)

Mis d/B
u
11-15

Date: Tuesday, 15/11/2005 8:46:50 AM
 User: *Alba Panzuto

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: JACK
Job Number	: 23772		
Estimate Number	: 10527		
P.O. Number	:	Part Number	: D33361
This Issue	: 15/11/2005 S.O. No. :	Drawing Number	: D3336 REV A
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 15/12/2005 Qty: 10 Um: Each
Checked & Approved By	:		
Comment	: Est. A05.01.13 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: _____

For D3336-1 Jack P/N: 76508

Possible Supplier: Auto Parts Product Specification sheet is required

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure Product Specification sheet is attached

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Drill and Tap base of jack using DT8761 as per Dwg D3336

2-Check ram length, then tack weld as per Dwg D3336

3-Drill and Tap ram as per Dwg D3336

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Date: Tuesday, 15/11/2008 8:46:51 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK

Job Number: 23772

Part Number: D33361

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion

